

79466

January-26-12 1:04:58 PM

N900040100

Setup Start *NS1*

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Date:

Date:

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79466

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Item ID: D2053 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Bracket
 Start Date: 26/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8/2/06/15		(+12)			
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D2053 using CNC Brake	0.00 0.00				(12)			8/2/06/19
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/2/06/19		(+12)			

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Item ID: D2053 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Bracket
 Start Date: 26/01/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	Chemical Conversion Coat per QSI005 4.1	0.00							
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150

HandFinish

Hand Finishing

Memo

0.00

12 12/6/20

160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
-----	---	------	--	--	--	--	--	--	--

160

Powdercoat

Powder Coating

Memo

 START TIME:
 OVEN TEMPERATURE:
 FINISH TIME:

 11:30
 325°F
 12:00

0.00

12X Ø M.F. 12/06/20

170	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

170

QC

Quality Control

Memo

0.00

12x f 12/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Start Date: 26/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>004</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/6/21 *[Signature]*
 MJS 12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-26-12 1:05:02 PM

Page 1

Work Order ID: 79466

79466

Parent Item: D2053

D2053

Parent Item Name: Mounting Bracket

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP D02.03.18Added Rev.B NG(Issue this IPP with part number D2052)

IPP Rev:E now water jet 07-10-25 DD

IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.090

Purchased

No

100

sf

28.9000

0.0385

0.405263

M5052H32S 090

**

5052-H32 .090 Sheet

JIA 12-6-15

Location

Loc Qty

Loc Code

MAT022

28.9

118641

14

3019

14.9

3019

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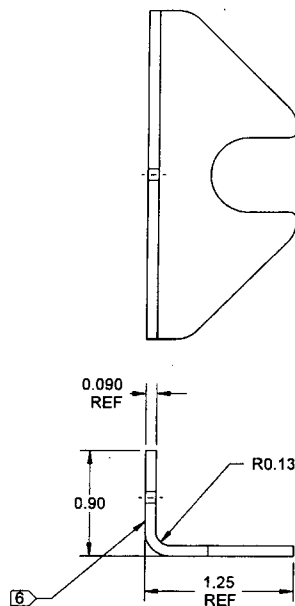
8 7 6 5 4 3 2 1

D

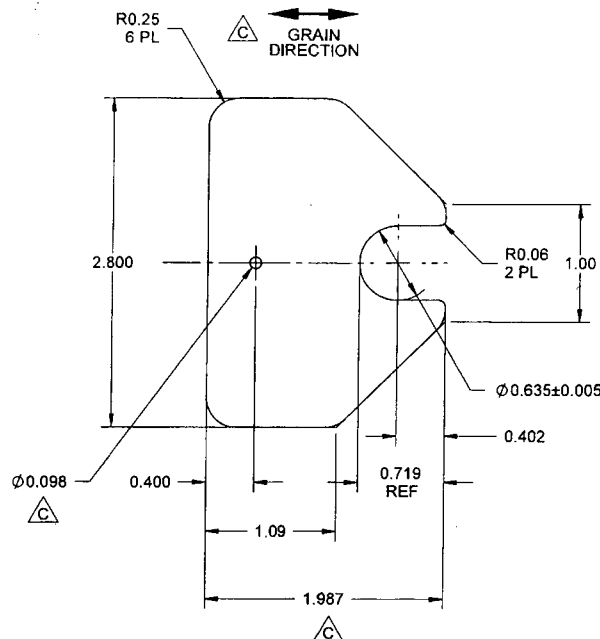
C

B

A



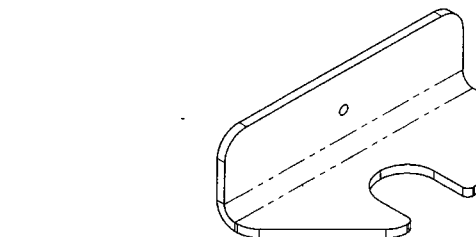
D2053 BRACKET



D2053F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.04 lbs



RECEIVED
ENGINEERING
DESIGN
NO. 79466-MLJ
12/01/26

RELEASED
08.05.13/11

C	1.987 WAS 1.979 (ZN B5-1); ADD WEIGHT (ZN A8-1); ADD IDENTIFICATION (ZN A4-1); ADD Ø0.098 HOLE FOR POWDER COAT MOUNTING (ZN B6-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDTEX (ZN A6-1); ADD 6061-T6 MATERIAL OPTION (ZN A5-1); ADD GRAIN DIRECTION (ZN D5-1); QTY (2) Ø0.213 MOUNTING HOLES REMOVED; REASON: PRODUCT IMPROVEMENT		PH	08.04.25
B	Ø0.635 WAS Ø0.437; 0.635 WAS 0.325		DS	02.03.12
A	NEW ISSUE		DS	92.01.12
REV.	DESCRIPTION		BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF 1	
DRAWN	RL			
CHECKED	MP			
MFG. APPR.	MP			
APPROVED	TH			
DE APPR.	TH	TITLE	SCALE	
DATE	08.04.25	BRACKET	NTS	
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8 7 6 5 4 3 2 1

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